



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3571-3
Job Sheet 167891



Part No: D3571-3

Job Qty: 3 ea

Part Name: Guide



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/7/17

Job Tracking No:

Due Date: 11/21/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Note: SALES ORDER 1077

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	3 Ea	11/20/17	11/20/17	0.00	0.00	Start Up Machining		FM
100	Bandsaw	3 pcs	11/20/17	11/20/17	0.00	0.36	Bandsaw1		FM
110	CNC Vertical Machining	3 pcs	11/20/17	11/20/17	0.47	1.86	HAAS 1		FM
120	QC	3 pcs	11/20/17	11/20/17	0.00	0.00	QC2		FM
130	QC	3 pcs	11/20/17	11/20/17	0.00	0.00	QC8		FM
140	HandFinish	3 pcs	11/20/17	11/20/17	0.00	0.13	HandFinish1		DA 17-11-27
145	Outsource	3 pcs	11/20/17	11/20/17	0.00	0.00			2017-11-27 JSL
150	Powdercoat	3 pcs	11/21/17	11/21/17	0.00	0.09	Powdercoat3		BR 17-11-28
155	Packaging	3 pcs	11/21/17	11/21/17	0.00	0.00			DAS
160	QC	3 pcs	11/21/17	11/21/17	0.00	0.00	QC3		38
170	Packaging	3 pcs	11/21/17	11/21/17	0.00	0.00	Packaging3		9-89
180	QC21-SA	3 Ea	11/21/17	11/21/17	0.00	0.00	QC21		JL

Part Op 100 - Cut blank 2.90 " long

Descriptions: 110 - 1- Mill as per Folio FA681 Rev: AA & Dwg D3571 Rev: A
150 - START TIME: 4:55 O.U.T: 3:00 FINISH 5:25

M 136320

ST040

NOV 3 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.750X01.500	1	21	0	0

Part Specifications

Specifications could not be found.

Plex 11/7/17 3:06 PM dart.Michaud-Febrille.Victoria

5013877

DART
AEROSPACE
S013877



Guide

PART NO: D3571-3
Revision:
Operation: HandFinish
Change No:

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 11/25/17
Job No: 167891

DART AEROSPACE LTD		Work Order:	
Description: Guide		Part Number:	D3571-3
Inspection Dwg: D3571 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

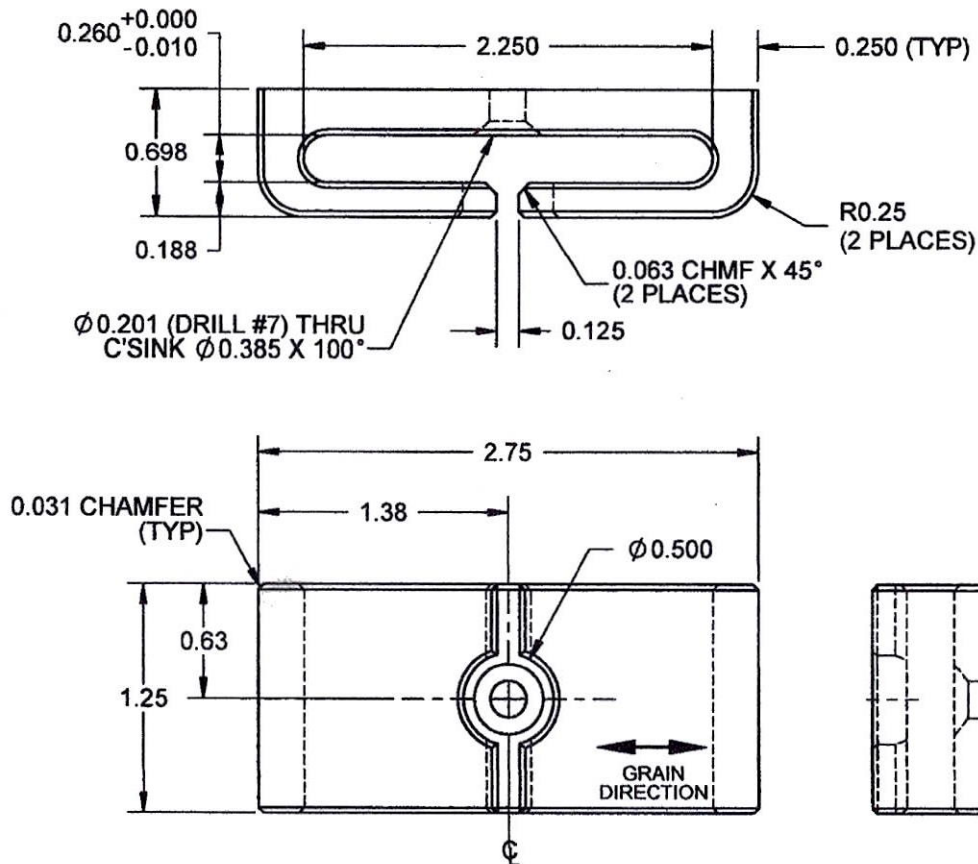
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	0.698	/		Vern MLe6	
2.75	+/-0.030	2.754	/		" "	
1.38	+/-0.030	1.372	/		" "	
1.25	+/-0.030	1.249	/		" "	
0.63	+/-0.010	0.626	/		" "	
0.031 chamfer	+/-0.010	0.030	/		" "	
Ø0.500	+0.006/-0.001	0.503	/		" "	
Ø0.201	+0.005/-0.001	0.203	/		" "	
R0.25	+/-0.030	0.250	/		" "	
0.260	+0.000/-0.010	0.259	/		PIN GAGE	
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	0.386	/		Vern MLe6	
0.125	+/-0.010	0.127	/		Vern MLe6	
2.250	+/-0.010	2.244	/		Vern MLe6	
0.250	+/-0.010	0.254	/		" "	
0.188	+/-0.010	0.189	/		" "	
0.063 chamfer	+/-0.010	0.058	/		" "	

Measured by: FM	Audited by: B.P	Prototype Approval:	N/A
Date: 17-11-25	Date: 17-11-27	Date:	N/A

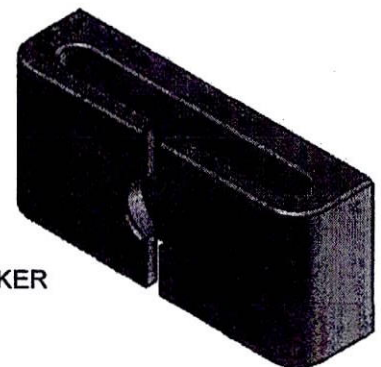
Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 2 OF 2
DATE 07.01.29		TITLE GUIDE	SCALE 1:1

RELEASED07.04.12 *[Signature]***D3571-3 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT CL

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Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4314-1
Job Sheet 167875



Part No: D4314-1

Job Qty: 16 ea

Part Name: Shim



Part Weight: 0 lbs

Job Created: 11/7/17

Due Date: 12/8/17

Type: **SOLD**

Ship Via:

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Mario Poulin

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	16 Ea	12/7/17	12/7/17	0.00	0.00	Start Up Waterjet1		SC
100	Waterjet	16 pcs	12/7/17	12/7/17	0.02	0.84	Waterjet1		SC DAS
120	QC	16 pcs	12/7/17	12/7/17	0.00	0.00	QC8		38
130	Small Fab	16 pcs	12/7/17	12/7/17	0.00	0.37	Small Fab		38
150	QC	16 pcs	12/7/17	12/7/17	0.00	0.00	QC5		38
160	HandFinish	16 pcs	12/8/17	12/8/17	0.00	0.46	HandFinish1		2017-11-28 JSL
170	QC	16 pcs	12/8/17	12/8/17	0.00	0.00	QC7		38
180	Packaging	16 pcs	12/8/17	12/8/17	0.00	0.00	Packaging3	ST085	38
190	QC21-SA	16 Ea	12/8/17	12/8/17	0.00	0.00	QC21		DAS

Part Op 100 - 1-Cut as per Dwg D4314

Descriptions: 130 - COUNTER SINK AS PER DWG

DEC 01 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6S.125	0	61	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Shim	0.201Inches + 0.005 - 0.001	0.206 0.200	Diameter	
2	Shim	0.386Inches + 0.006 - 0.001	0.392 0.385	Diameter	
3	Shim	0.670Inches ± 0.030	0.700 0.640		
4	Shim	1.125Inches ± 0.010	1.135 1.115		
5	Shim	0.600Inches ± 0.030	0.630 0.570		
6	Shim	2.100Inches ± 0.030	2.130 2.070		
7	Shim	1.330Inches ± 0.030	1.360 1.300		
8	Shim	0.125Inches ± 0.010	0.135 0.115		

DART
AEROSPACE
S012758



Shim

PART NO: D4314 - 1
Revision:
Operation: Start up Operation
Change No:

Dart Aerospace Ltd.

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Mfg Date: 11/23/17

Job No: 167875

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	11.04.28	New issue	K-J	



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: M6061T6B0.750X01.500 Revision: 6061-T6 Bar .750 X 1.50														
100	Receive Ft	S013876	167891	0 ft	0	m137513	Start Up Machining		Stock	11/25/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		1		0	0									

Plex 1/8/2018 9:51 AM Dart.Boucher.Sylvie